						\$,	~ 1. 1 1	, it
	er ID 95669 hary 16, 2013 11:46:10 AM		*9566	39*		, = 1, 15	runee nen en n a	 	Za	n Page 1
Revision ID: Item Name: Start Date:	D2365 Wearplate 1/16/2013	. 17	Accept	*N900		100)* s	etup Start Stop	· ··· · · · · · · · · · · · · · · · ·	S1* S2*
Required Date: Reference:	1/31/2013 Req'd Qty: 32	*32*		Customer:						
Approvals:	Process Plan: WW	Date: \3-1-			ate:		R	tun Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	· · · · · · · · · · · · · · · · · · ·		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	·								
D2365 100 *100* Waterjet FLOW CNC Waterjet	Det		0.00 0.00 Prog Rev: C	_ 2-			- 32			JM13.1-25
*110 * QC Quality Control	QC2- Inspect parts Memo	off machine FAI/FAIB	0.00				32	. •		Jm 13-1-24
120 * * 1 2 0 * QC Quality Control	QC8- Inspect parts	- second check 🗸	0.00				. 37	3-13-1	DI-750	09 6 %

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-C	01	NFORN	MANCE / UPD	ATE	QA Closed:	Date:	
Work Orde	·					DISPOSITION				AGAINST DE	<u> </u>	PROCESS	
Part N	- No	-				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs			o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination		-	on Incomplete ions Incomplete/U	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	et	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea	n Strip in	n Tube ု		Countersink Cut Too Short Drill Holes		Mislabe Misread	led		Positioned V Power Loss/		Other
i	1	Ripples in	i Reua		1	ווויטופא חוויטן	L	Jouser					· · · · · · · · · · · · · · · · · · ·

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	Work Order ID 95669 Wednesday, January 16, 2013 11:46:10 AM			*956		Page 2		
Item ID: Revision ID: Item Name:	D2365 Wearplate			Accept	*N90004010) () *	Setup Start Stop	1421
Start Date: Required Date: Reference:	1/16/2013 1/31/2013	Start Qty: 32.00 Req'd Qty: 32.00	*32* *32*		Cust Item ID: Customer:			IV.57
Approvals:	Process Pla	un:			Date:		Run Start Stop	"NRT"
Sequence ID/ Work Center II	D	Operation Description Chemical Conversion Co.	at per OSI005 4.1	Set Up/ Run Hours	Tool ID Tool # Plan Cod		U	Reject Insp. Number Stamp
130 HandFinish Hand Finishing		Мето		0.00		32	15	13-1-28
¹⁴⁰ *1⊿∩*		QC3- Inspect Part Finish		0.00		32	ŀ	J_11
QC Quality Control		Мето		0.00				
*150		Small Fab		0.00		32		
Small Fab Small Fab		Memo Install Insert	as per Dwg D2365	0.00		ب م		3/ 2

		3
DQA:	Date:	
-		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCN.	23 / 140									(QA Closed:	Da	te:	
Work Orde	r:				DISPOSITION				AGAINST D	EP	ARTMENT	PROCESS		·
Part N					Rework Scrap		,1	Sk.d-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality Other
NCR N	0				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	_	Rec/Stor	e/Packaging Supplier		Other
Root				Descri	ption of work order update	I	nitial	Ad	ction		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verificatio	n	QC Inspector
Doc/Data										İ		 	ļ	
Equip/Tooling		•	}											
Operator		,					,			1				
Material										١			l	
Setup			1			ł				-				
Other														
Process										ļ				
Supplier]								-				
Training	_	ļ									:			
Unapproved		<u> </u>	<u> </u>			<u>L</u>							;	
						AUL	T CATE	GORY			-			·
Landin	ng Gear				General	_	1		г	\neg	o "			0
1	Bending				Bend	\vdash	Grain		<u> </u>	_	Ovalized	A . I	\vdash	Pressure/Forced
	Centre N	ot Conce	ntric to C	^{D/S} -	BOM/Route	-	Hardwa				Over/Under		-	Temperature/Cure Weld
	Cracks			<u> </u>	Broken/Damaged	\vdash	4	ion Incomplete	// I	_	Part Incorre		_	Wrong Stock Pulled
1	Crushed/	'Crimped		. -	Burrs	-	4	tions Incomplete	/Unclear	-	Part Lost/Mi Part Moved	issing	Ш	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte		-	—	Part Moved Positioned V	Mrong		
	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe			\dashv	Positioned v	-		Other
	Inspectio	•	Tube		Cut Too Short	\vdash	Misrea	u	L		rower Luss/	Juige		Oulei
	Ripples in			<u> </u>	Drill Holes	-	Offset	Calibration						
	Torque V			` <u> </u>	Drawing	H	-	Calibration Sequence	-					
	Turning S			 	Finish	-	-	•						
	Wave/Tv	vist in Tu	be	l l	Folio	1	Joursia	e Dimensions						

Work Orde Wednesday, Jan				*956	69*				Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2365 Wearplate 1/16/2013 1/31/2013	Start Qty: 32.00 Req'd Qty: 32.00	*32* *32*	Accept	*N900040 Cust Item ID: Customer:	1100	★ Setu	p Start Stop	*NS1* *NS2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00 SmD 0.00 B.). 20	Tool ID Tool #				Reject Insp. Number Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location <u>5</u>	0.00		(°	/e/3/	cy/3.	32
*180		QC21- Final Inspection -	Work Order Release	0.00			ſ	3/1	131 \$
QC Quality Control		Memo		0.00			1		·

Mis DI3)

						•					DQA:	Da	ate: _	
NCR: Y	es /	No				WORK ORDER NON-	COP	NFORM	MANCE / UPDATE		QA Closed:		ate:	
						DISPOSITION			AGAINS	T DE	PARTMENT			
Work Orde	er:	· · · · · · ·				_	,	ŀ		_	· •			
						Rework	↓		Skid-tube Crosstub		_	Water Jet		Engineering
Part N	۱o					Scrap	┨. ╿		Machining Small Fa		4	d. Eng. Coor.	-	Quality
						Use-as-is	↓ /		oforming Finishir	~}—	Rec/Stoi	re/Packaging	-	Other
NCR N	No					Work Order Update]	l	Large Fab Composi	te	j	Supplier		Ш
Root	\neg				Descr	iption of work order update		Initial	Action		Sign &			
Cause	D	ate S	step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	on	QC Inspector
Doc/Data				· · · · · ·			\Box							
Equip/Tooling														
Operator														
Material														
Setup					,									
Other		1											İ	
Process													ĺ	
Supplier		.									<u> </u>			
Training		j			1	\ .								
Unapproved							丄							
							AUI	LT CATE	GORY					
Landi	ng Gea	•			_	General		-		_	٦			
	—	nding			L	Bend	<u>_</u>	Grain		\vdash	Ovalized			Pressure/Forced
	\vdash	itre Not (Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		-	Temperature/Cure
	\vdash	cks			_	Broken/Damaged	\vdash	⊣	on Incomplete	\vdash	Part Incorre		—	Weld
	\vdash	shed/Cri	mped		<u> </u>	Burrs	<u> </u>	-1	ions Incomplete/Unclear	<u> </u>	Part Lost/M	issing	Ш	Wrong Stock Pulled
	Cut	fs			ı	Contamination		Mainte	enance	1	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

· Picklist Print

Wednesday, January 16, 2013 11:46:09 A

Work Order ID:

95669

Parent Item:

D2365

Parent Item Name:

Wearplate

Start Date: 1/16/2013

Required Date: 1/31/2013

Page 1

Start Qty: 32.00

Required Qty: 32.00

Comments:

IPP Rev A

Removed from 9 Digit 05-12-05 JLM

	(IPP Rev:B	Now On Waterjet	08-	04-04 JLM	Verified By:	EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF		Purchased	No			100	Each B902	33 (64)	2	64		53/0	1/20
M6061T6S.063 D 37 6061-T6 .063 Sheet	96 -	Purchased	No			150	sf	340.4625	0.0047	0.2	8/		Jm13-1-

<u>Location</u>	Loc Qty	Loc Code	
MAT021	340.4625		
123135	124.4625		12335
124003	216		

											DQA:	Date	:
NCR: Y	es	/ No				WORK ORDER NON-	OP	NFORN	AANCE / UP		QA Closed:	Date	::
			-			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er: _					Dawark -	٦		Skid-tube	Crosstube	Ì	Water Jet	Engineering
Part N	lo		····			Rework Scrap		١	Machining noforming	Small Fab Finishing	4	d. Eng. Coor.	Quality Other
NCR N	lo					Use-as-is Work Order Update]		Large Fab	Composite	Nec/Stol	Supplier	
Root	T				Descri	ption of work order update	Ti	Initial	Ac	tion	Sign &		
Cause	1	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													}
Equip/Tooling													ļ
Operator					:								
Material			1										
Setup													
Other				İ									·
Process			İ										
Supplier	П												
Training													
Unapproved			<u> </u>						<u></u>		<u> </u>		
							AUI	LT CATE	GORY				
Landi	ng G	iear				General		-		_	7	г	
		Bending				Bend	L	Grain			Ovalized	1	Pressure/Forced
	Ш	Centre N	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa	ire		Over/Under	} ~	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	ion Incomplete		Part incorre	 -	Weld
		Crushed/	Crimped			Burrs	Ŀ	-	tions Incomplete	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	enance		Part Moved		
		Heat Tre	at			Countersink	L	Mislabe	ele d		Positioned V	· · ·	_
1	П	Inspectio	n Strin ir	Tube		Cut Too Short	1	Misrea	d		Power Loss/	Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order: 9569	
Description: Wear Plate	Part Number: D2365	
Inspection Dwg: D2365 Rev: C	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1,252	_		U	Jimas
1.000	+/-0.010	1-004"	_		V	
0.625	+/-0.010	0.678	_		V	
0.250	+/-0.010	0.253"	_		J	
0.500	+/-0.010	0.506"			U	
R0.125	+/-0.010	0.152,	-		× RG	
Ø0.290	+0.006/-0.001	0.292"	-		v	
Ø0.191	+0.005/-0.001	0.192"	_		7	

Measured by:	J.M	Audited by:	09	Prototype Approval:	N/A
Date:	13-1-25	Date: 12	5-01-213	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue P/O D350-616-015	KJ/JLM 1,0	
В	08.10.09	Dimensions revised	KJ/DD 🛠	N/Z

NCR:	Yes / N	0	WORK ORDER NON-CONF
	,	•	

DQA:	Date:	

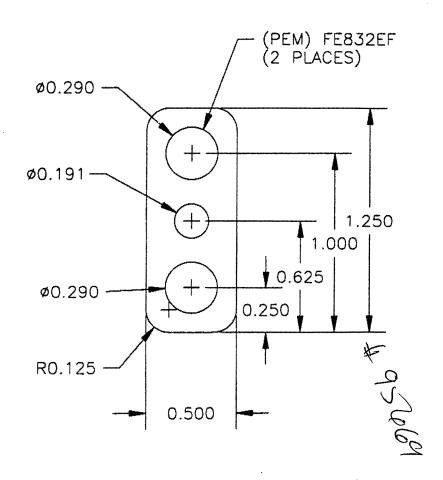
NCR:	⁄es	/ No				WORK ORDER NON-C	ON	IFOR I	MANCE / UPI	DATE	QA Closed:	Date	:
Work Order:									AGAINST DE	DEPARTMENT/PROCESS Water Jet Engineering			
Part N	-			Rework Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Use-as-is Use-as-is Vork Order Update Large Fab Composite Supplier					Quality Other				
Root					Descri	ption of work order update	li	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator													
Material					}								
Setup													
Other			ļ	ļ			١.						
Process									İ				
Supplier											20	9	
Training											(V) -	3	,
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (Sear				General		•			•	_	
		Bending				Bend	Ш	Grain			Ovalized	_	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	Ha		Hardware		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspection Incomplete			Part Incorred	-	Weld
		Crushed/	Crimped			Burrs		Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	<u> </u>	Part Moved		
		Heat Trea	at			Countersink		Mislab	eled		Positioned V		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples ir	n Bend			Drill Holes		Offset					
		Torque W	Vaves in I	Extrusio	on [Drawing		Out of	Calibration				
		Turning S	equence	<u>!</u>	Г	Finish		Out of	Sequence				
	Wave/Twist in Tube Folio					Г	Outside Dimensions						

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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT.			
CHECKED	APPROVED	DRAWING NO.	******************************	REV.	¢
BW	Y	D2365	SHEET	1 OF	1
DATE		TITLE	***************************************	SCA	E
95:01:20		WEAR PLATE		2	2;1
C	95:03:06	0.191 WAS 0.197			

RELEASE)



ACID ETCH & ALODINE PER OST OS 4.1.1) A INSTITUL FERSZEF (2 PLS) AFTER ALODINE

A15+ 244 /3+6, -56

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES

										DQA:	Date	:	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
		<u></u>								QA Closed:	Date	:	
Work Orde	֥				DISPOSITION			AG	AINST DE	PARTMENT	PROCESS		
WOIK OIGC	·				Rework	1		Skid-tube Cros	sstube		Water Jet	Engineering	
Part N	0.				Scrap	1		<u> </u>	all Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1		· —	nishing	Rec/Stor	e/Packaging	Other	
NCR N	0				Work Order Update]		Large Fab Com	posite				
Root				Descri	ption of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Ooc/Data									:				
quip/Tooling		1				1							
Operator						1			•				
Material		ļ											
etup						1							
Other									i				
Process		1				Ì							
Supplier				ļ									
Training [*.	*		
Jnapproved													
						AUL	T CATE	GORY					
Landin	g Gear			-	General	_	7		_	3	r-	¬ !	
	Bending				Bend		Grain		_	Ovalized	-	Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa			Over/Under	 	Temperature/Cure	
<u> </u>	Cracks				Broken/Damaged	L	Inspection Incomplete			Part Incorre	<u>}</u>	Weld	
	_	/Crimped		L	Burrs	<u> </u>	Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination				Contamination	<u> </u>	4	enance		Part Moved			
	Heat Tre				Countersink	_	Mislabe			Positioned V		¬,	
		on Strip in	Tube		Cut Too Short	\perp	Misrea	d	L	Power Loss/	Surge	Other	
	Ripples i			<u> </u>	Drill Holes	<u> </u>	Offset					***************************************	
		Naves in I		n L	Drawing	<u> </u>	4	Calibration					
		Sequence			Finish		-1	Sequence					
	Wave/Twist in Tube Folio							Outside Dimensions					

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